

Date: Wednesday, 5/23/2007 3:45:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE ASSEMBLY
Job Number : 32512	
Estimate Number : 11053	
P.O. Number : <u>NIA</u>	Part Number : D2873043
This Issue : 5/23/2007 S.O. No. : <u>NIA</u>	Drawing Number : D2873 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31192	Material : <u>NIA</u>
Written By : _____	Due Date : 6/10/2007 Qty: 30 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est A 05.09.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR
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Comment: Qty.: 0.3237 f(s)/Unit Total : 9.7115 f(s)
 6061T6 BAR
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x01.000)
 Identify for D2873-3
 Batch: 104598

SG 05.06.28 30

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 1.000" x 0.375" x 3.700" long

SG 05.06.28 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA and Dwg D2873
 Identify as D2873-3 Dwg Rev A Folio Rev AA

SG 05.06.28 30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG 05.06.28 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:45:31 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 32512

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 07/06/29 36

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg.D2873

ml 07/06/29 X30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counted
En 07/07/03 (X30)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mf 07-07-06 (X30)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

mf 07-07-09

10.0

MS20426AD46

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

m 2566 -

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 90.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

m 18136 -

mf 07-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:45:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 32512

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

MF

07-07-10

30

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/10

counted
(132)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/07/10 (30)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(30)
07/07/11

Job Completion



U 07.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32512
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

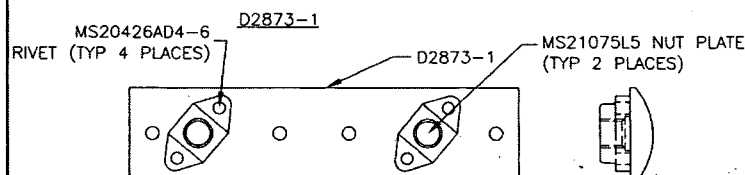
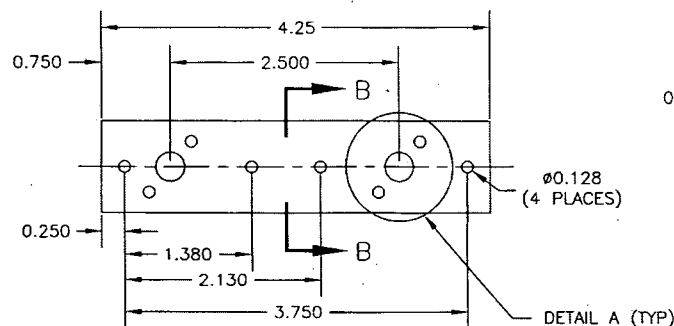
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

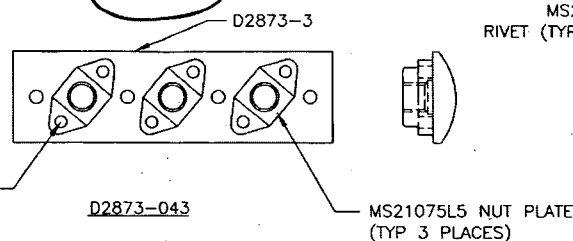
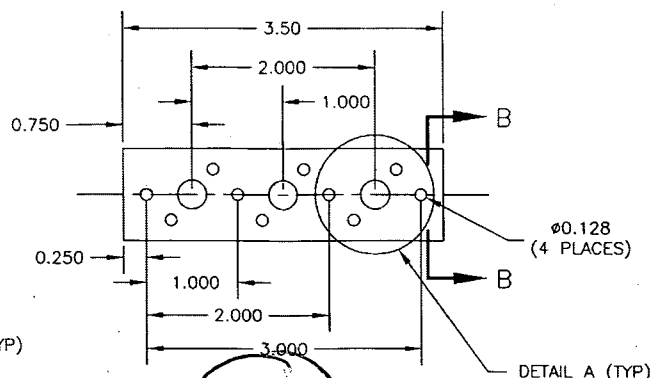
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.502	✓			
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	.742	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.243	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.132	✓			
0.359	+/-0.010	.361	✓			
Ø0.316	+0.006/-0.001	.315	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.231	✓			

Measured by: <i>BC</i>	Audited by: <i>gmk</i>	Prototype Approval:	N/A
Date: 07-06-28	Date: 07/06/28	Date:	N/A

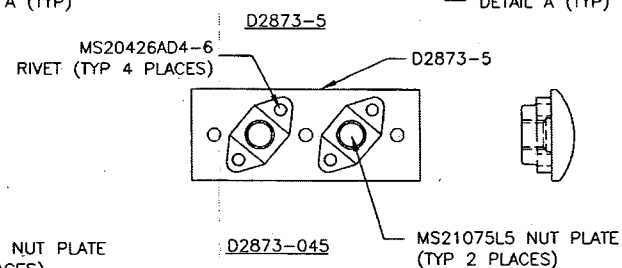
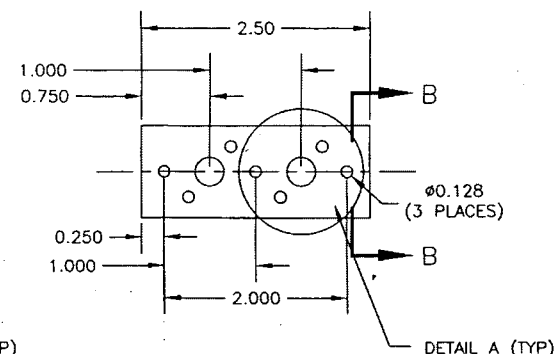
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



D2873-041



D2873-043



D2873-045

D2873-1/-3/-5 RADIUS BLOCK

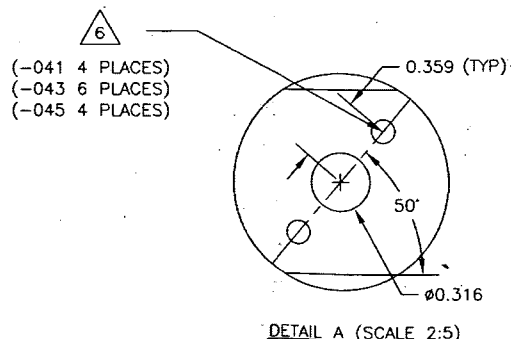
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 X 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

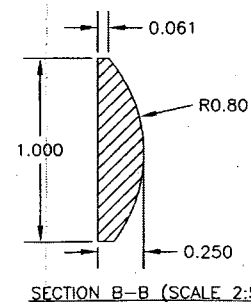
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED 05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

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 ENGINEERING
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 32512